

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: FWD ADJUSTABLE BLADE SUPPORT ASSY		
Job Number	: 43059						
Estimate Number	: 13433						
P.O. Number	:			Part Number	: PB674300115		
This Issue	: 29/10/2008 S.O. No. :			Drawing Number	: B6743001 P.7		
Prsht Rev.	: NC			Project Number	: N/A		
First Issue	: / / Type : LARGE FAB ASSY			Drawing Revision	: B1		
Previous Run	: 41367			Material	:		
Written By	:			Due Date	: 05/11/2008 Qty: 1 Um: Each		
Checked & Approved By	: MF 08-11-04						
Comment	: Est Rev:A 08-06-26 new issue DD verified by:ec						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	PB6743001257	Inner Tube	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)	
		Inner Tube batch: 343070 ✓	pel 08-11-19
2.0	PB6743001249	Inner Tube Bushing	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)	
		Inner Tube Bushing batch: 49877 ✓	pel 08-11-19
3.0	PB6743001253	Gusset	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)	
		Gusset batch: 41492 ✓	MF 08-11-14
4.0	PB6743001254	Gusset	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)	
		Gusset batch: 41493 ✓	MF 08-11-14
5.0	PB674300171	PB67-43001-71	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)	
		PB67-43001-71 batch: 41512 ✓	MF 08-11-14

		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 29/10/2008 10:10:06 AM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD ADJUSTABLE BLADE SUPPORT ASSY

Job Number: 43059

Part Number: PB674300115

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

- 1- make a 0.090" chamfer in the 1.00" hole before welding
- 2- assemble parts and weld as per dwg

PCL 08/11/19

①

7.0 QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

Mos/11/20

②

8.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Soslu20

③

9.0 MS124780

HELICAL INSERT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

HELICAL INSERT

BH M17935

SAB 08-11-27

10.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

- 1- grind weld flush in area of PB67-43001-249 only

- 2- install helical insert as per dwg

SAB 08-11-27

④

11.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/11/27

⑤

12.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

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S 08/11/27

13.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

- 1- MASK TUBE FROM BASE TO GUSSET

- 2- Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

M-f 08/12/01

⑥

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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Date: Wednesday, 29/10/2008 10:10:06 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD ADJUSTABLE BLADE SUPPORT ASSY

Job Number: 43059

Part Number: PB674300115

Job Number:



Seq. #: Machine Or Operation:

Description :

START TIME:

9:10
01

(D)

OVEN TEMPERATURE:

320
01

FINISH TIME:

9:40

m-1

08/12/01

14.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Fx 08/12/01

(D)

15.0

PB674300173

20 Degree Cover Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

20 Degree Cover Plate

batch: 841513.

Fx.

16.0

PB674300183

PB67-43001-83



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

PB67-43001-83

batch: 841516.

Fx.

17.0

MS27039110

Screw



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Screw

batch: m109031

Fx.

18.0

NAS1149F0316P

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

WASHER

batch: m109031

Fx.

19.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

- 1- match drill cover to existing holes in support
- 2- assemble as per dwg

Fx 08/12/01

(D)

W/O:		WORK ORDER CHANGES					
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Date: Wednesday, 29/10/2008 10:10:06 AM
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Job Number: 43059		Part Number: PB674300115
Job Number:		
Seq. #:	Machine Or Operation:	Description :
20.0	QC5	INSPECT WORK TO CURRENT STEP  Comment: INSPECT WORK TO CURRENT STEP m 08/12/01 (1)
21.0	PACKAGING 1	PACKAGING RESOURCE #1  Comment: PACKAGING RESOURCE #1 Identify and Stock Location: Finishing FL 08/12/01 (1) 08/12/02 (JF)
22.0	QC21	FINAL INSPECTION/W/O RELEASE  Comment: FINAL INSPECTION/W/O RELEASE MF 08-12-01
Job Completion		

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

650Eh #



